Dart Aerospace Ltd. Thursday, 6/15/2006 1:51:12 PM Kim Johnston User **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : PLATE Customer : 27592 Job Number **Estimate Number** : 10425 : D32191 **Part Number** P.O. Number :NIA S.O. No. : 11A **Drawing Number** : D3219 REV A : 6/15/2006 This Issue : N/A Project Number Prsht Rev. : NC : NIA : MACHINED PARTS **Drawing Revision** Type First Issue : 27150 Material **Previous Run Due Date** : 6/30/2006 Qty: 30 Um: Written By Checked & Approved By Comment ESR B 06.05.25 Waterjet EC **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: M6061T6S125 6061-T6 .125 Sheet Total: Comment: Qty.: 0.1012 sf(s)/Unit 3.0366 sf(s)6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: M103092 FLOW WATER JE 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: F Prog Rev: 2-Deburr if necessary

3.0

4.0

QC2

QC8

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Each

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE		By Date		Approval Mfg / Design Mgr	Approval QC Inspector		
		•							
							·		

NCR:			WORK ORD	DER NON-CONFORMANC	E (NCR)							
DATE		Description of NC	Corrective Action Section B			Verification	A					
	STEP	Section A	Initial Design Mgr	Action Description Sign & Section C		Approval Design Mgr	Approval QC Inspector					
		,										
						·						

Part No:	PAR #:	Fault Category: N	ICR:	Yes No DQA:	Date: 06/06/27
NOTE: Date & initial all entries			•	QA: N/C Closed:	Date:

Thursday, 6/15/2006 1:51:12 PM Date: Kim Johnston **Process Sheet** User: Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 27592 Part Number: D32191 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary. DIMENSIONAL CHECK 6.0 Comment: DIMENSIONAL CHECK PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: INTA DOCUMENT CONTROL DC 8.0 Comment: DOCUMENT CONTROL Inspection Level 21 206,06,26 Job Completion

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W/O:			WOF	RK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE		GE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
			•						
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	₹)			
D.47F	отер	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign 8 Date	Section Section		Design Mgr	QC Inspecto
·									
Part No	o:	PAR #:	Fault Category:	NCR:	Yes No	DQA:		Date:	
NOTE: D	ate & initia	Lall entries			QA: N/C C	losad:		Date:	

H:\forms\Quality Assurance\approved forms\NCRWO revC

DART AEROSPACE LTD	Work Order:	27592
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

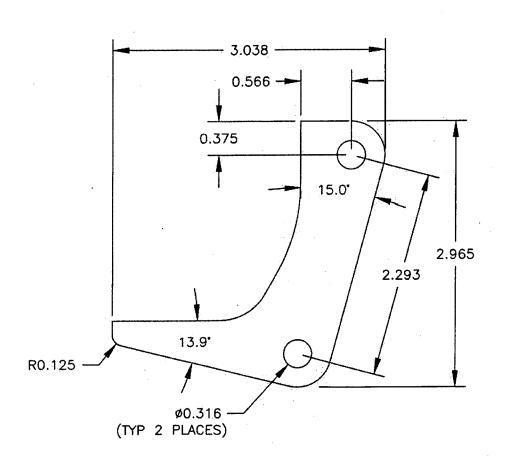
FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Со	mments
Ø0.316	+0.005/-0.000	0.316	J		vern		
2.293	+/-0.005	2.294	V.		VERA		
2.965	+/-0.010	2.963			vern		
0.566	+/-0.010	0.565	\checkmark		Hight GUA	El	
0.375	+/-0.010	0.368			vern	1	
R0.125	+/-0.010	RO. 125			RADIUS GU	AGL	
0.125	+/-0.010	0.122	V		Vern	0	
13.9	+/-0.010	14.0	V		Angle Mote	e e	
							
Measured by: M Audited by: Prototype Approval:						proval:	N/A
Date:	0, 21	Date:	06-06	522		Date:	N/A
Rev Date A 04.04.19	Change New Issue					vised by /JLM	Approv#d





the second second	1.						
DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,					
CHECKED	APPROVED,	DRAWING NO.	REV. A				
#	4	D3219	SHEET 1 OF 1				
DATE		TITLE	SCALE				
 03.10.10		PLATE	1:1				
 Α .	03.10.10	NEW ISSUE					





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)

(REF DART SPEC M6061T6S.125)

- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING

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WORK ORDER NO 27592

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